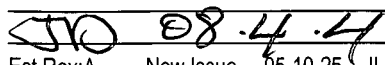


Date: Friday, 04/04/2008 9:22:07 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FWD X-TUBE
<b>Job Number</b> :	38398		
<b>Estimate Number</b> :	10006		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2889
<b>This Issue</b> :	04/04/2008	<b>Drawing Number</b> :	D2889 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	38397	<b>Material</b> :	
	<b>Type</b> :	<b>Due Date</b> :	30/04/2008
		<b>Qty:</b>	1 Um: Each
<b>Written By</b> :			
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A New Issue 05-10-25 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D6005180	Crosstube material
-----	----------	--------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	

*B34687**EL 8-4-24*

2.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



**Comment:** LANDING GEAR RESOURCE 1  
 1-Bend D2889 as per Dwg D2889 and Folio FT001

*EL 8-4-24*

3.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1
-----	-------------	----------------------

**Comment:** LANDING GEAR RESOURCE 1*N/A*

1-Deburr and Polish

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------

**Comment:** DIMENSIONAL CHECK OF X-TUBES*2004-24*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Acid etch and alodine as per QSI 005 4.1  
 Inside and outside of tube

*N/A*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:22:07 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38398

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O 38623

208-04-24 (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

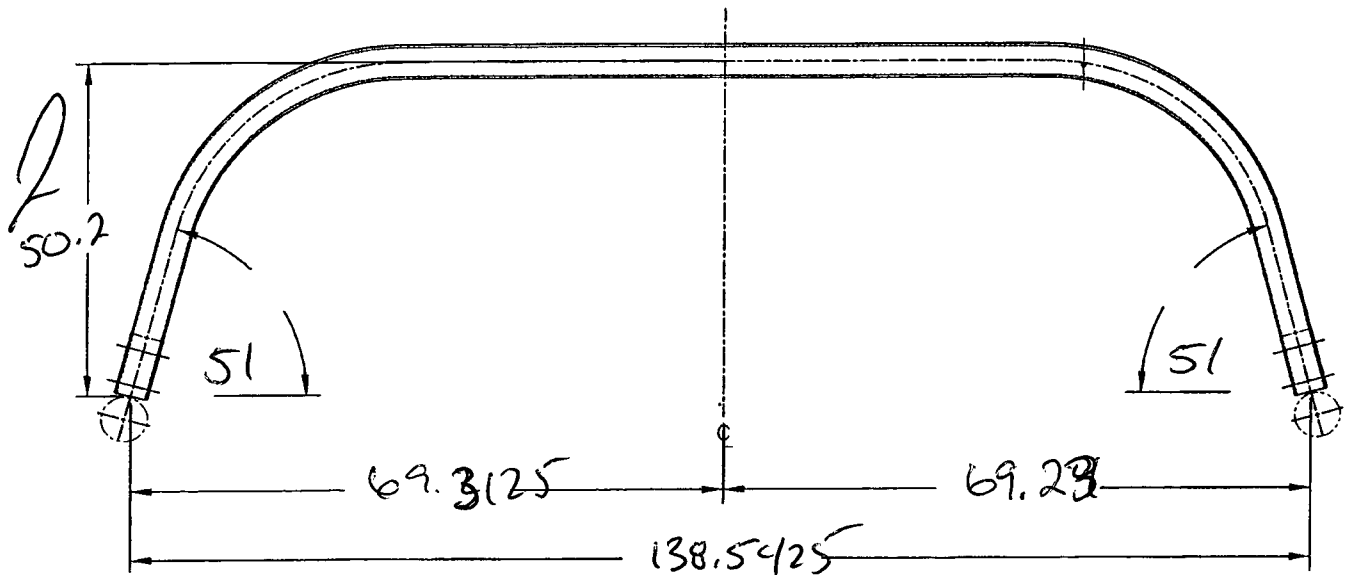
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 22392
<b>Description:</b> Crosstube Fwd		<b>Part Number:</b> D2889
<b>Inspection Dwg:</b> D2889 <b>Rev:</b> B		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

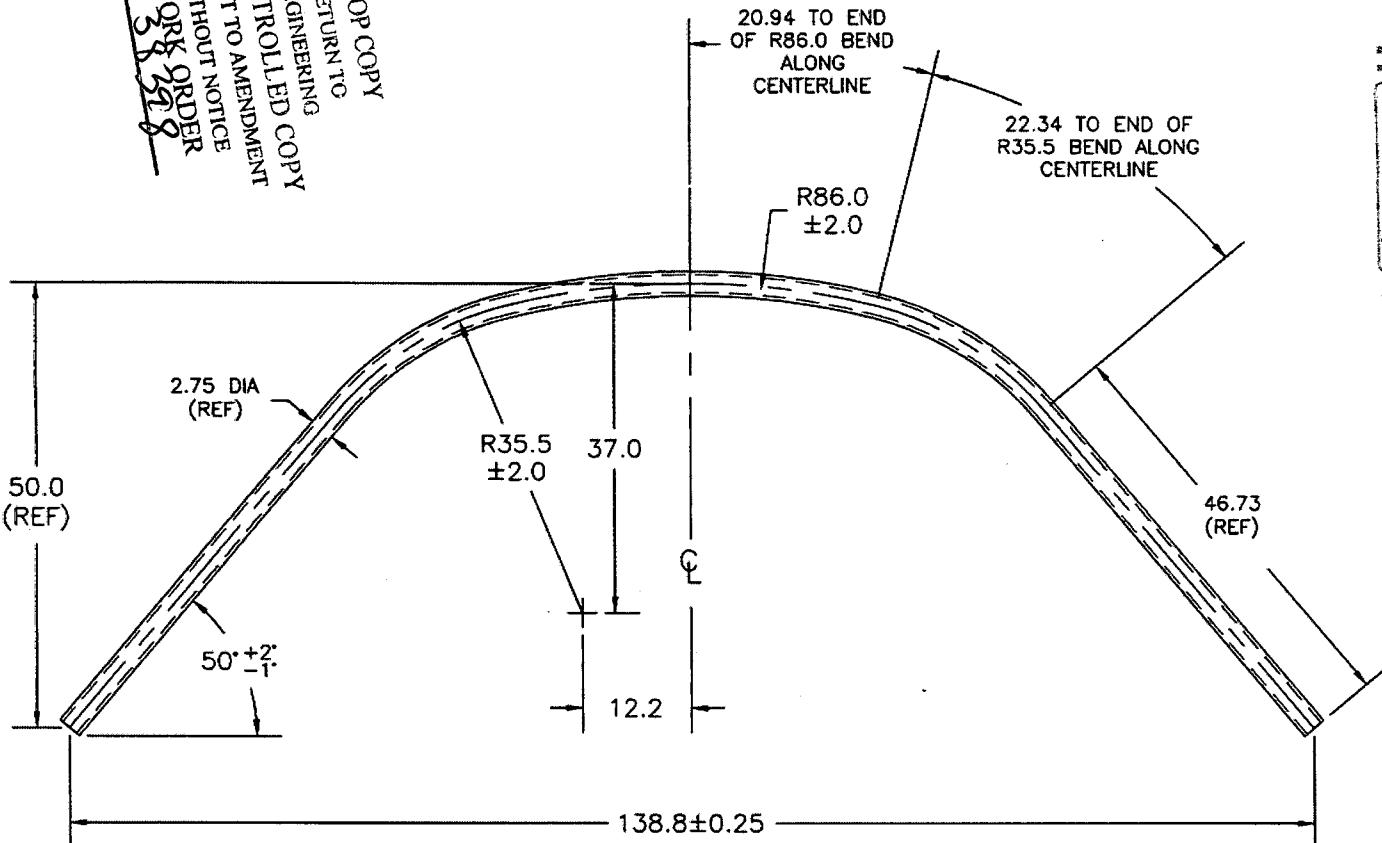
QC15 Inspection	
Date	08-04-2011

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]



RELEASED  
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
#	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2889
DATE	TITLE	REV. B
02.10.18	FWD CROSS TUBE	SHEET 1 OF 1
A	99.05.21	SCALE
B	02.10.18	1:20
ADD TANGENT LENGTHS; CHANGE NOTES		



#### NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 (Ø2.75 OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38398